



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4110-2

Job Sheet 168363



Part No: D4110-2

Job Qty: 2 ea

Part Name: Door Doubler, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/17/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP Rev:A 10.09.24 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/16/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	2 pcs		11/16/17	0.00	0.08	Waterjet1		SC
110	QC	2 pcs		11/16/17	0.00	0.00	QC2		SC DAS 38
120	QC	2 pcs		11/16/17	0.00	0.00	QC8		SC 38 9-88
130	Small Fab	2 pcs		11/17/17	0.00	0.31	Small Fab		SC DAS 38 9-88
140	QC	2 pcs		11/17/17	0.00	0.00	QC5		SC 38 9-88
150	Packaging	2 pcs		11/17/17	0.00	0.00	Packaging3	ST OFE	SC 38 9-88
160	QC21-SA	2 Ea		11/17/17	0.00	0.00	QC21		SC 38 9-88

Part Op 100 - 1-Cut as per Dwg ***make from D4110-1*** Dwg Rev: A Prog Rev: A 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1- C'sink holes as per dwg

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	45	0	0

Part Specifications

Specifications could not be found.

Plex 11/13/17 2:49 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Completed By			
Start up Operation D4110-2 Rev Date: 11/22/17 Job No: 168363				head hand / Supervisor Approval Verification			
				QA Coordinator Approval			
				ed Wrong Dimensions per tolerance			
				Part Lost/Missing			
Root Cause		Pressure/		Out of Sequence		Part Moved	
Environment ☐	No Re-verification ☐	Bending ☐	Centre Not ☐	Off-set ☐	Drawing ☐	Finish ☐	
Design ☐	Operator ☐	Cracks ☐	Crimp/Kink/R ☐	Mislabeled ☐	Misread ☐	Turning Sequence ☐	
Doc/Data ☐	Offset/Setup ☐	Cuffs ☐	Crushing ☐	Fit/Function ☐	Misaligned/off center ☐		
Equip/Tooling ☐	Supplier ☐	Heat Treat ☐	Wave/Twist in Tl ☐	Instructions Incomplete/Unclear ☐			
Handling/Pre ☐	Training ☐	Marks/Chatter ☐	OTHER : ☐				
Material ☐	Use for Testing ☐						
Internal Transport ☐	Poor Information ☐						
Tribal Knowledge ☐	Rushing ☐						
LOA ☐	Product Improvement ☐						
Substation ☐	Process Improvement ☐						
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

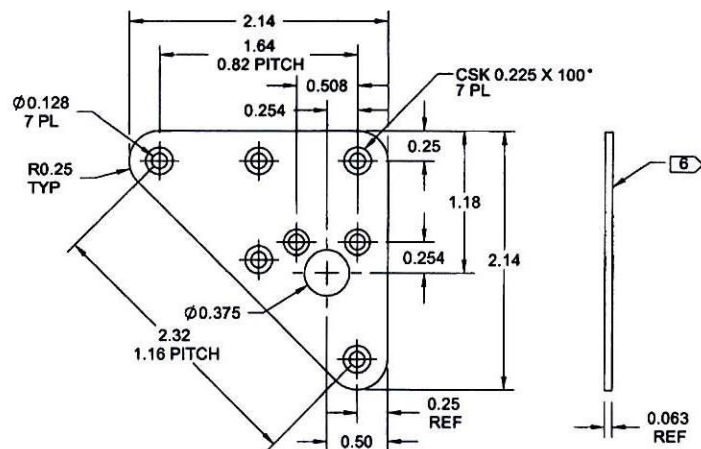
Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
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		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____							
Misidentified ☐		Past Due ☐									

SHOP COPY

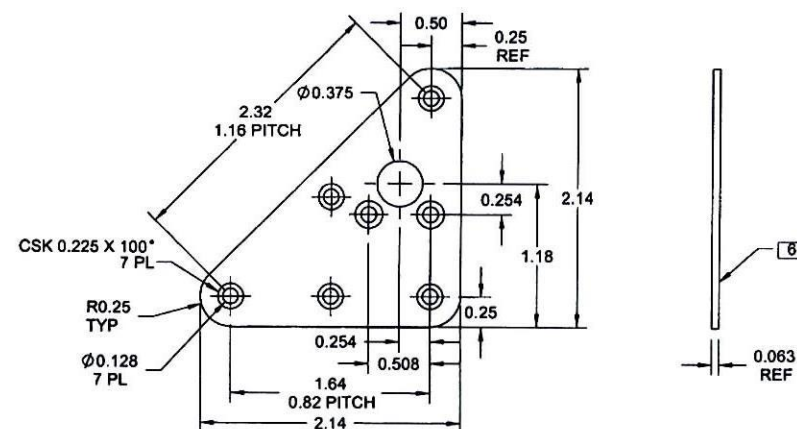
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 168563 ucs

171113



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE DOUBLER	SCALE NTS
DE APPR.			
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					